

NOTES:

1. FILLET WELD ALL AROUND.
2. MATERIAL: TOOL STEEL .25 AISI/O1, AISI/O6, AISI/A2, AISI/D2, AISI/S1, AISI/W1, AISI/W2 OR EQUIVALENT.
3. BREAK ALL SHARP EDGES. VISUAL INSPECTION IS SATISFACTORY.
4. QUANTITY: 2 EACH.

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9P91-023

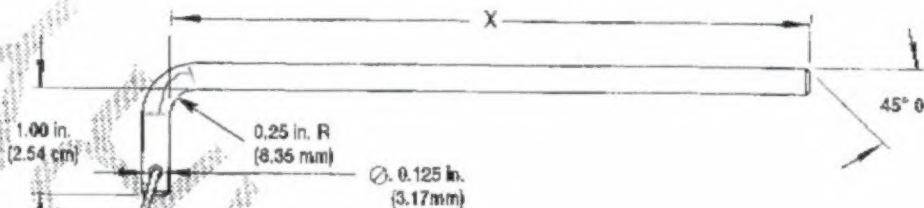
Figure 2. T306 Input/Lube Pump Drive T-Bolt Assembly - Field Fabricated

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ILLUSTRATED PARTS LIST



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REMOVE BEFORE FLIGHT

QUANTITY	"X"	ITEM CALLOUT	DESCRIPTION
2	1.50 in. (3.81 cm)	1	RIG PIN
2	2.50 in. (6.35 cm)	2	RIG PIN
2	2.75 in. (6.99 cm)	3	RIG PIN
1	3.75 in. (9.52 cm)	4	RIG PIN
1	4.00 in. (10.16 cm)	5	RIG PIN
1	5.00 in. (12.70 cm)	6	RIG PIN
1	6.00 in. (15.24 cm)	7	RIG PIN
A/R	NAS 1756-12	8	RED FLAG

NOTES:

1. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.
2. BREAK ALL SHARP EDGES.
3. MAKE FROM CRES 304 ROD SPC QQ-S-763 COND A; DIA 0.25 OR EQUIVALENT.
4. ATTACH STREAMER TO RIG PIN USING SUITABLE CABLE AND SWAGES.
5. PLACE ALL RIG PINS WITH STREAMERS IN A SUITABLE FABRIC POUCH.
6. CAN BE PURCHASED FROM: AVIBANK MFG., INC., PHOENIX, AZ 85018

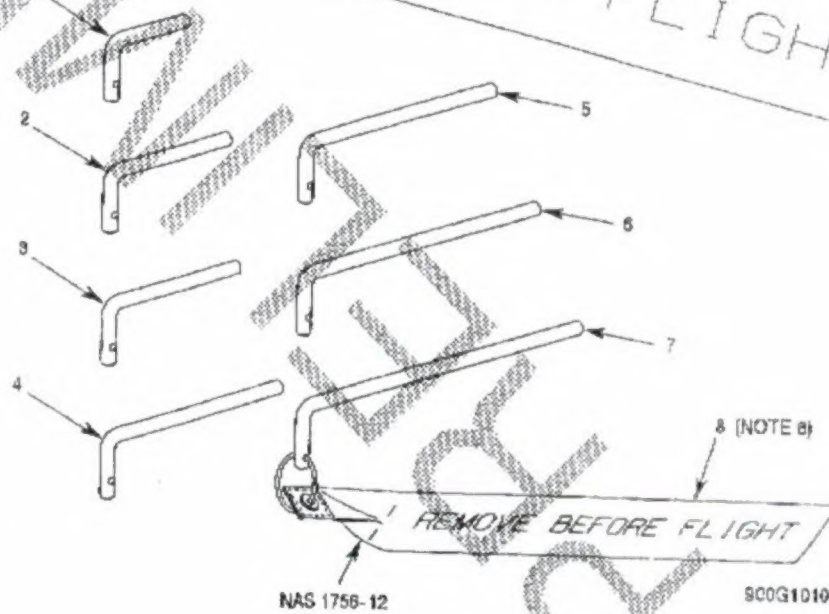


Figure 3. T501 Flight Control Rig Pins - Field Fabricated

RB 9006 1010006

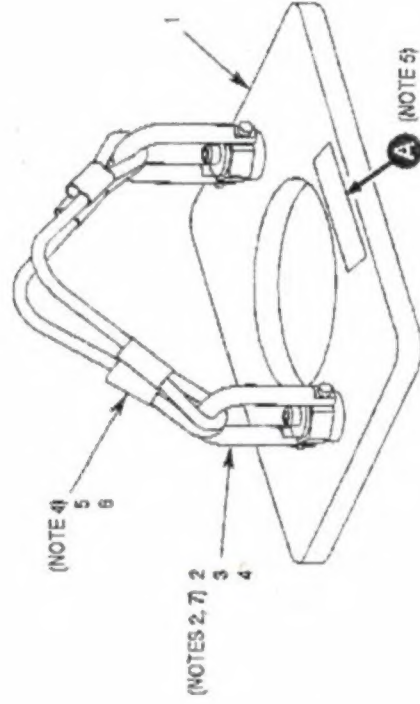
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COM'L FIELD SERVICE

CSP-900/PL-4



WARNING !
DO NOT USE TO LIFT HELICOPTER
OR ENTIRE ROTOR SUPPORT SYSTEM.

QUANTITY	STOCK SIZE	ITEM CALLOUT	DESCRIPTION
1	50 x 7.0 x 9.0	1	PLATE
2	CL-500-SHR	2	HOIST RING
2	MS5539T-45	3	WASHER
2	CL-5-IN	4	NUT
2	250 x 15	5	CABLE
4	MS51844-23	6	SLEEVE

900G1401010-101
9091-025

Tool - Field Fabricated
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CSP-900IPL-4

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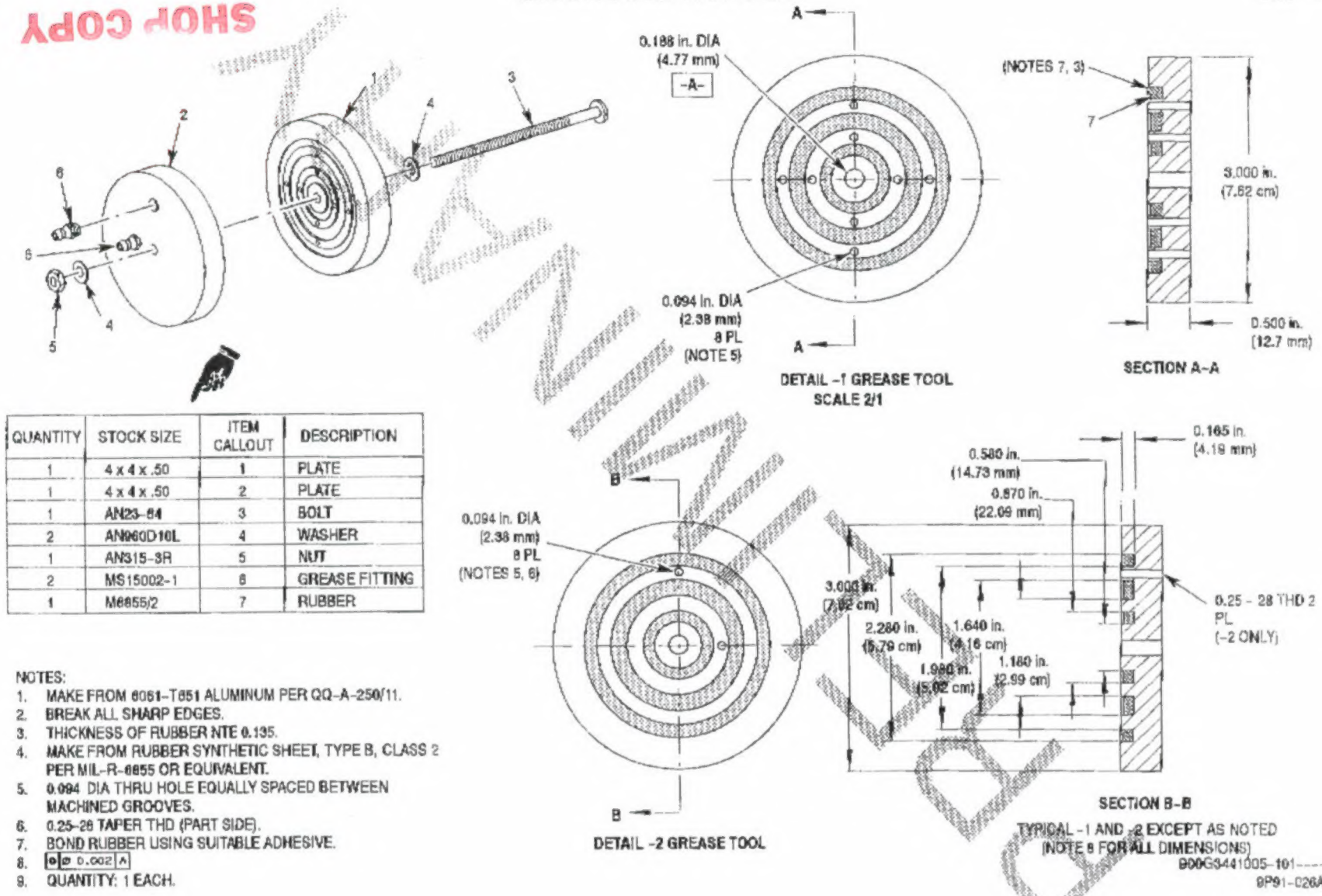
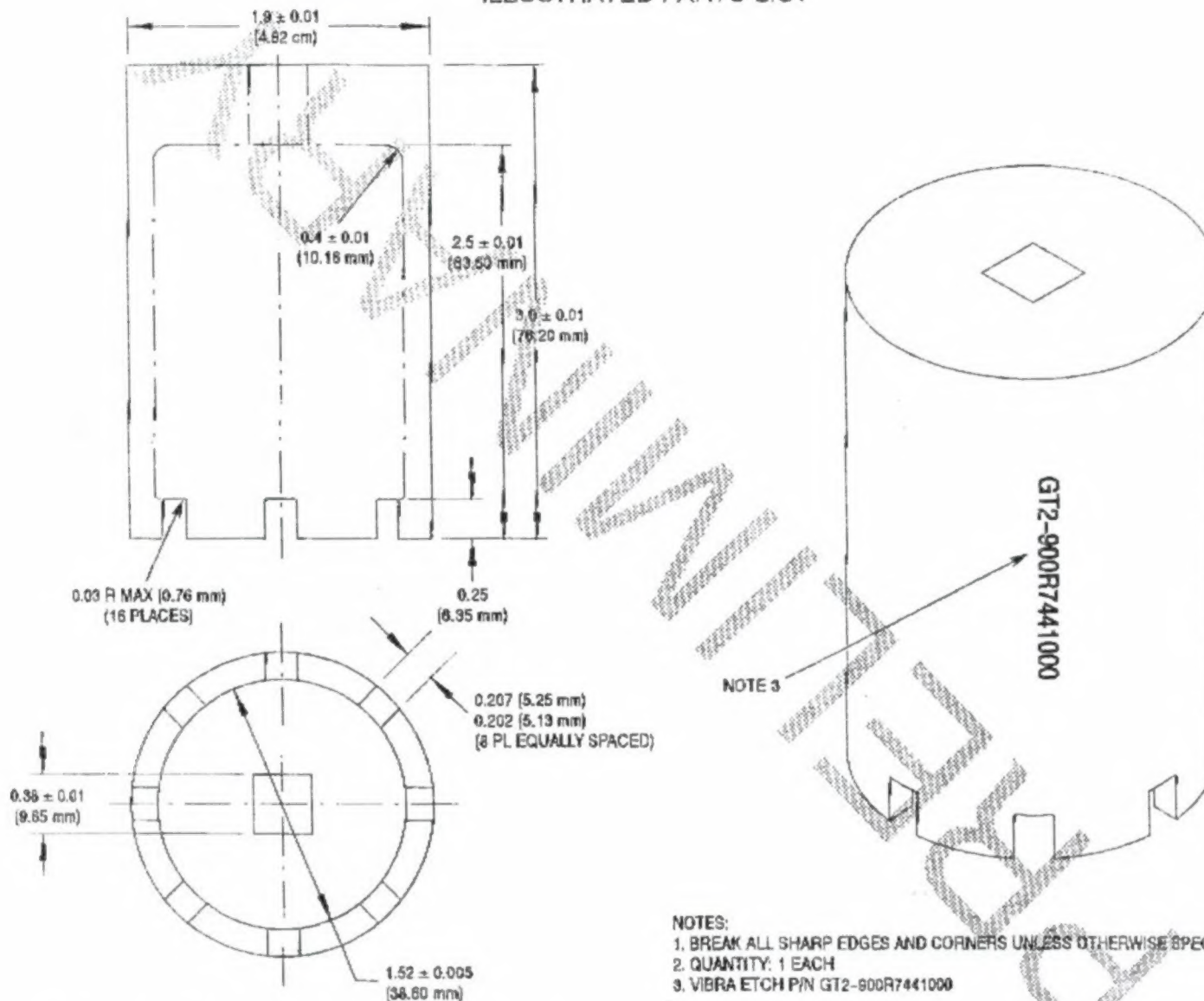


Figure 5. T604 Anti-Torque Bearing Grease Tool - Field Fabricated
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RB GT2-900R7441000

Figure 6. T603 Drive Shaft Nut Torque Socket - Field Fabricated

91-10-00

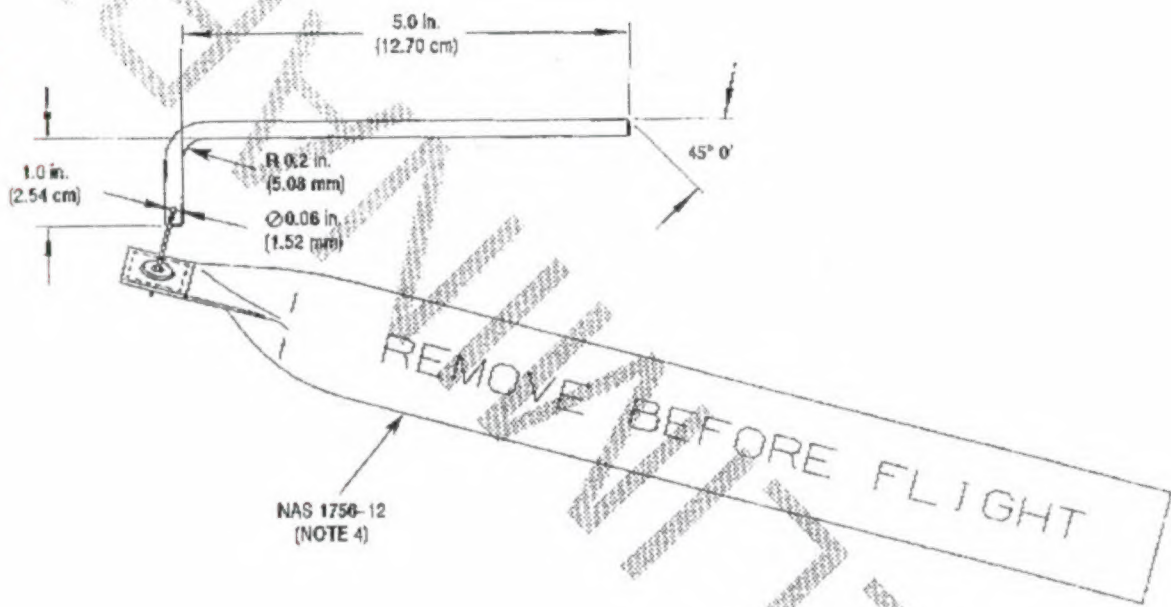
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COM'L FIELD SERVICE

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NOTES:

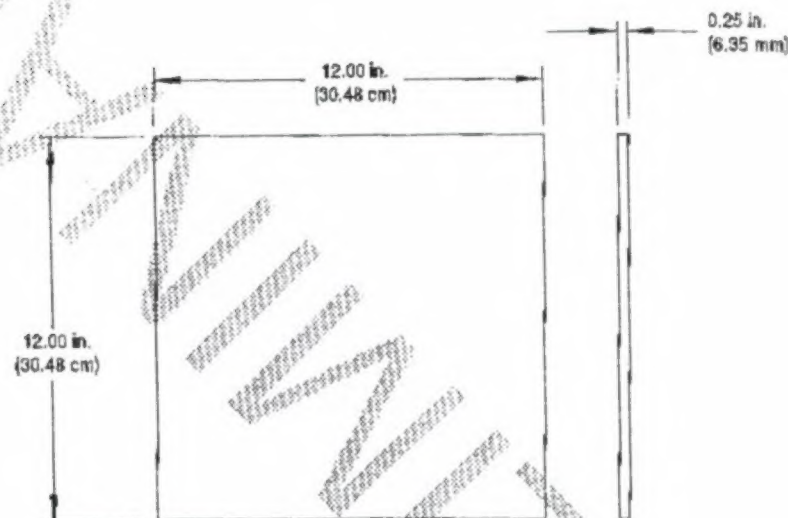
1. BREAK ALL SHARP EDGES.
2. MAKE FROM CRES 304 ROD SPEC QQ-S-783 COND A, DIA 0.187 IN. OR EQUIVALENT.
3. ATTACH STREAMER TO RIG PIN USING SUITABLE CABLE AND SWAGES.
4. CAN BE PURCHASED FROM: AVIBANK MFG., INC., PHOENIX, AZ 85018.
5. QUANTITY: 1 EACH.

RB 900G 8930001

Figure 7. T405 Engine Control Rig Pin - Field Fabricated

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906G3803082
9P91-029



RB 900623000102-1

NOTES:

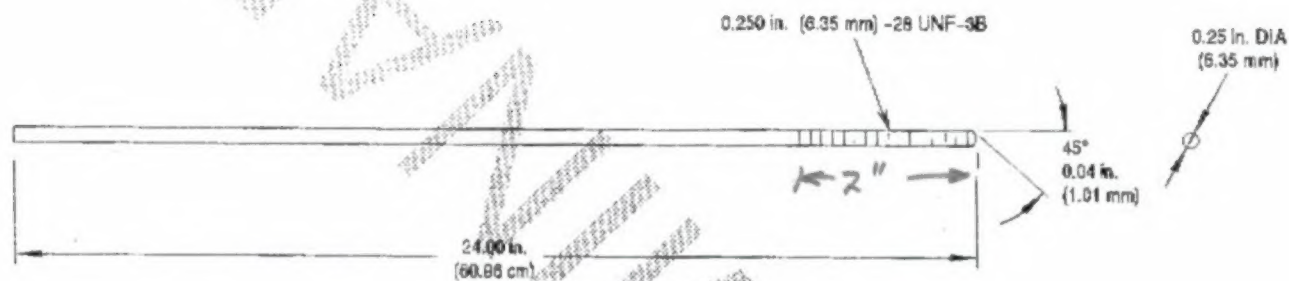
1. MATERIAL: STEEL OR ALUMINUM, TOOLING GRADE
2. USE MIL-L-7808 OR SUITABLE GREASE COMPOUND BETWEEN GREASE PLATES.
3. QUANTITY: TWO EACH

BP01-030

Figure 8. T206 Forward Jack Pad Grease Plate - Field Fabricated

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NOTES:

1. MAKE FROM TOOL STEEL 0.25 DIA.
AISI/O1; AISI/O8; AISI/A2; AISI/D2; AISI/S1; AISI/W1; AISI/W2 OR EQUIVALENT.
2. BREAK ALL SHARP EDGES.
3. QUANTITY: 4 EACH.

RB AFT1-900P7661000

AFT1-900P7661000
9P91-031

Figure 9. T801 Fuel Cell Rod - Field Fabricated

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Explorer

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NOTE:

1. MAKE FROM CHIP CHASER, OR ANY 0.020 INCH (0.508 mm) THICK SPRING STEEL [2 EACH].

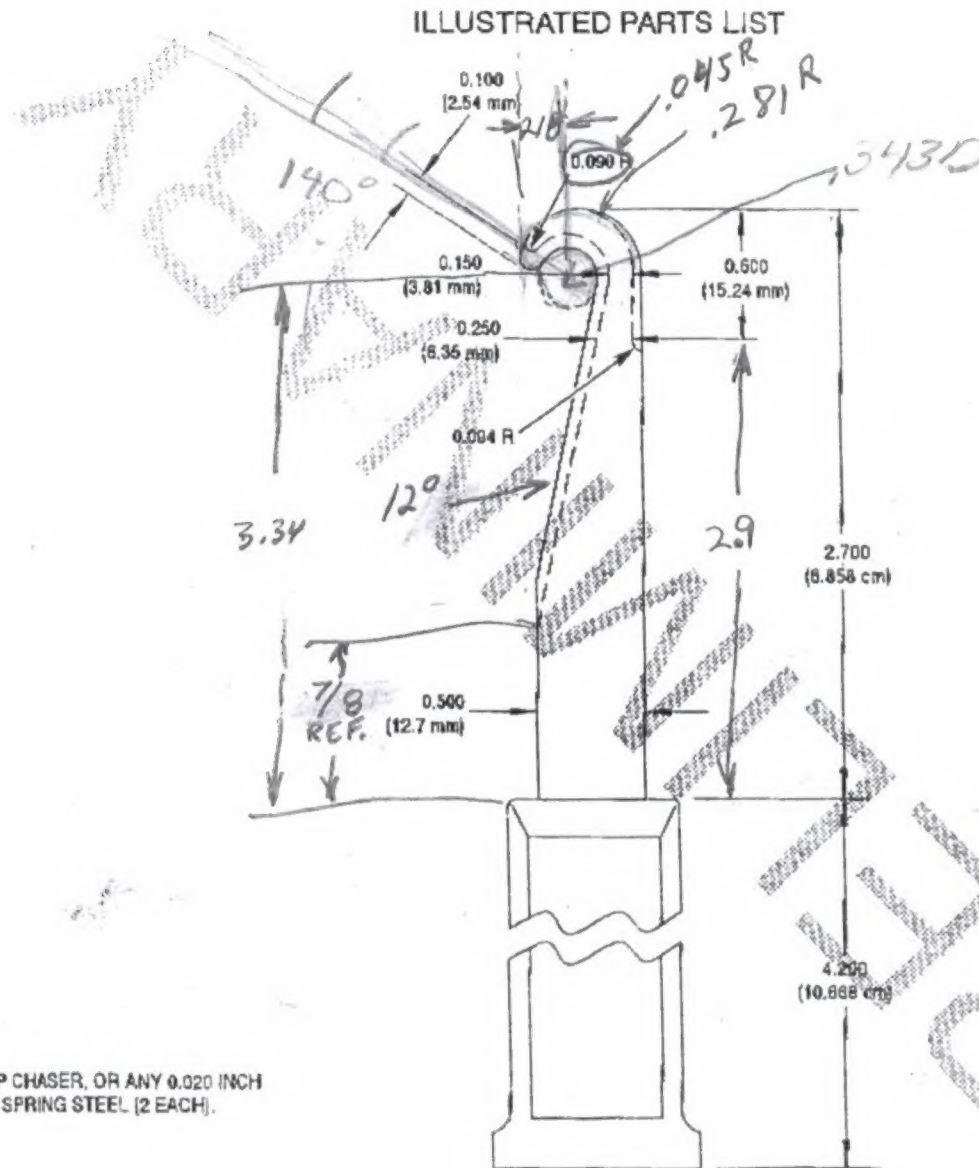
RB T907**FILE COPY**800-
9P01-034

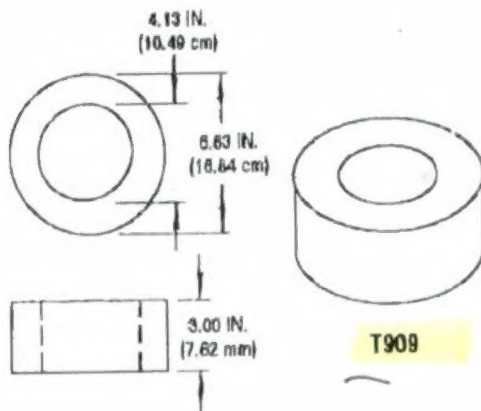
Figure 11. T907 Main Rotor Hub Bearing Removal Tool - Field Fabricated

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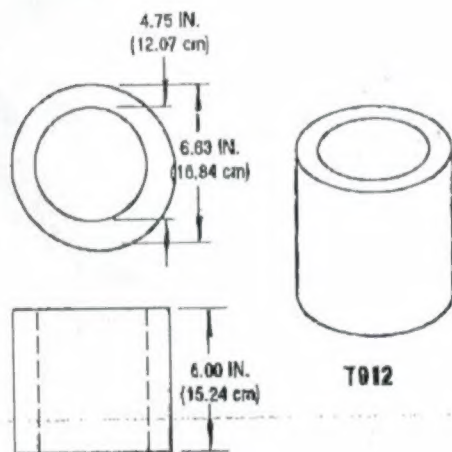
"CHIPCHASER"

P1584 MOC

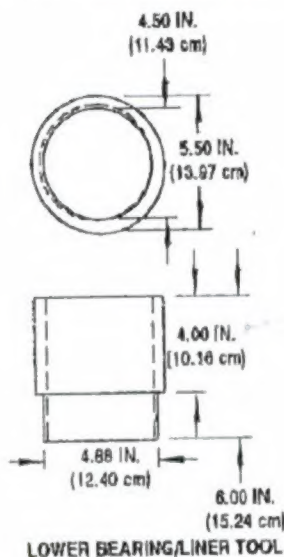
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UPPER SEAL INSTALLATION TOOL



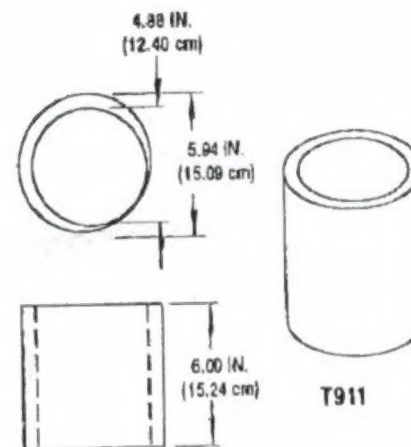
UPPER BEARING OUTER RACE INSTALLATION TOOL



LOWER BEARING/LINER TOOL



T910



LOWER BEARING OUTER RACE INSTALLATION TOOL

T911

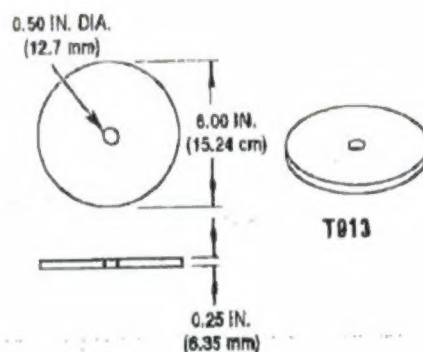
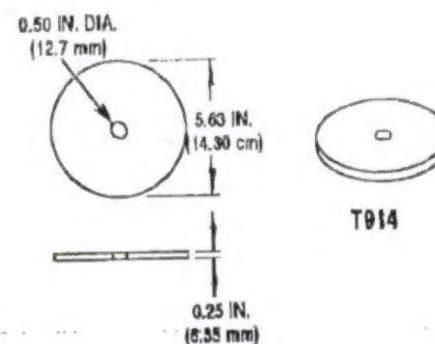


PLATE TOOL

T913



CENTER SEAL TOOL

T914

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Figure 17. Main Rotor Hub Details - Removal / Installation Tools (Sheet 1 of 2)

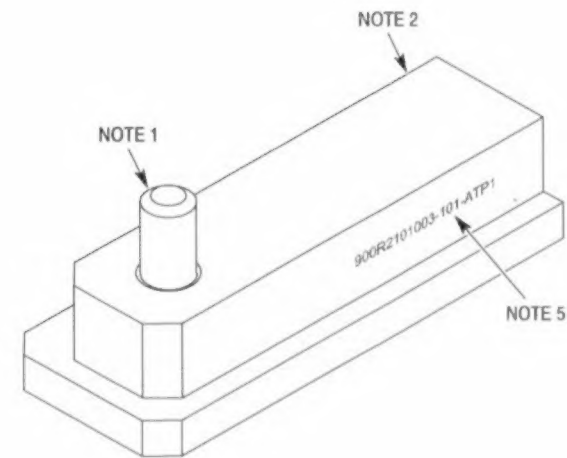
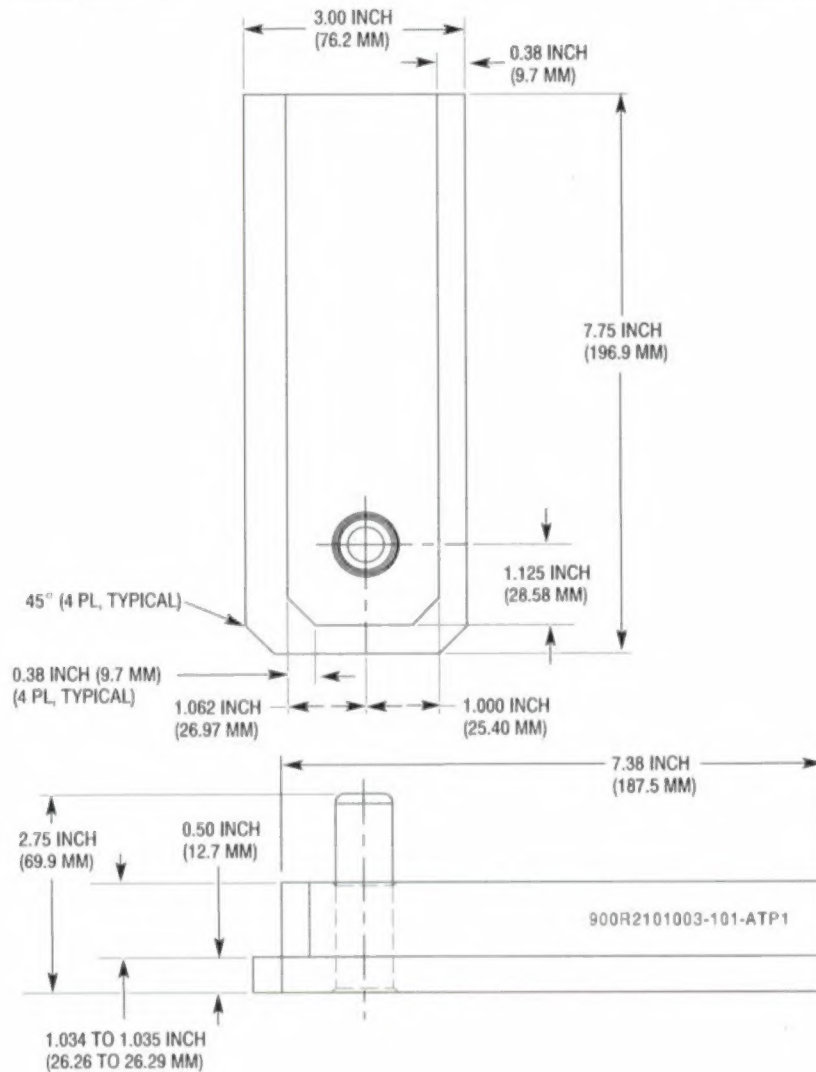
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MD RB T909



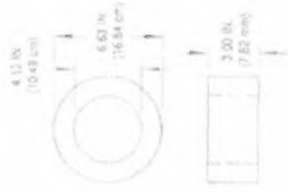
NOTES:

1. MAKE PIN FROM CRES OR EQUIVALENT \varnothing 0.75 INCH [19.1 MM] BY 2.75 INCH [69.9 MM] LONG), PRESS FIT INTO BODY, AND SLIP FIT, NO-SHAKE CONDITION W/ BUSHING 900R2101128-101.
2. MAKE BODY FROM ALUM 6061-T6 OR EQUIVALENT.
3. DEBURR AND BREAK ALL SHARP EDGES AND BEAD OR GLASS BLAST TOOL.
4. ANODIZE BLUE AFTER MACHINING. ALL DIMENSIONS APPLY AFTER ANODIZE.
5. VIBRA ETCH 0.25 INCH (6.4 MM) HIGH BLOCK FONT LETTER APPROX. LOCATION SHOWN OR EQUIVALENT.
6. USAGE: HOLD FLEXBEAM WEAR SHIM IN PLACE WHILE ADHESIVE DRIES.

9P91-047A

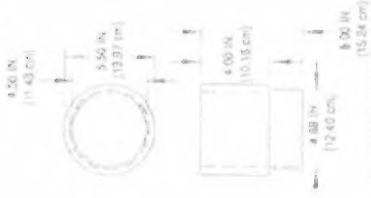
Figure 17. T908 Flexbeam Wear Shim Installation Tool – Upper and Lower Hub

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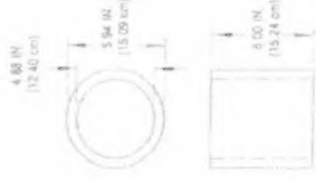
T909
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UPPER SEAL INSTALLATION TOOL



T910
335.00

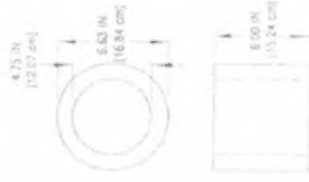
LOWER BEARING LINER TOOL



483.00

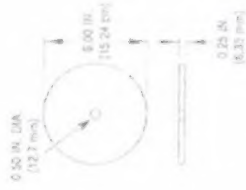
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LOWER BEARING OUTER RACE INSTALLATION TOOL



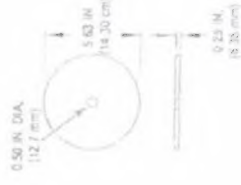
T912
515.00
New

UPPER BEARING OUTER RACE INSTALLATION TOOL



T913

PLATE TOOL



T914

CENTER SEAL TOOL

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Figure 18. Main Rotor Hub Details - Removal / Installation Tools (Sheet 1 of 3)
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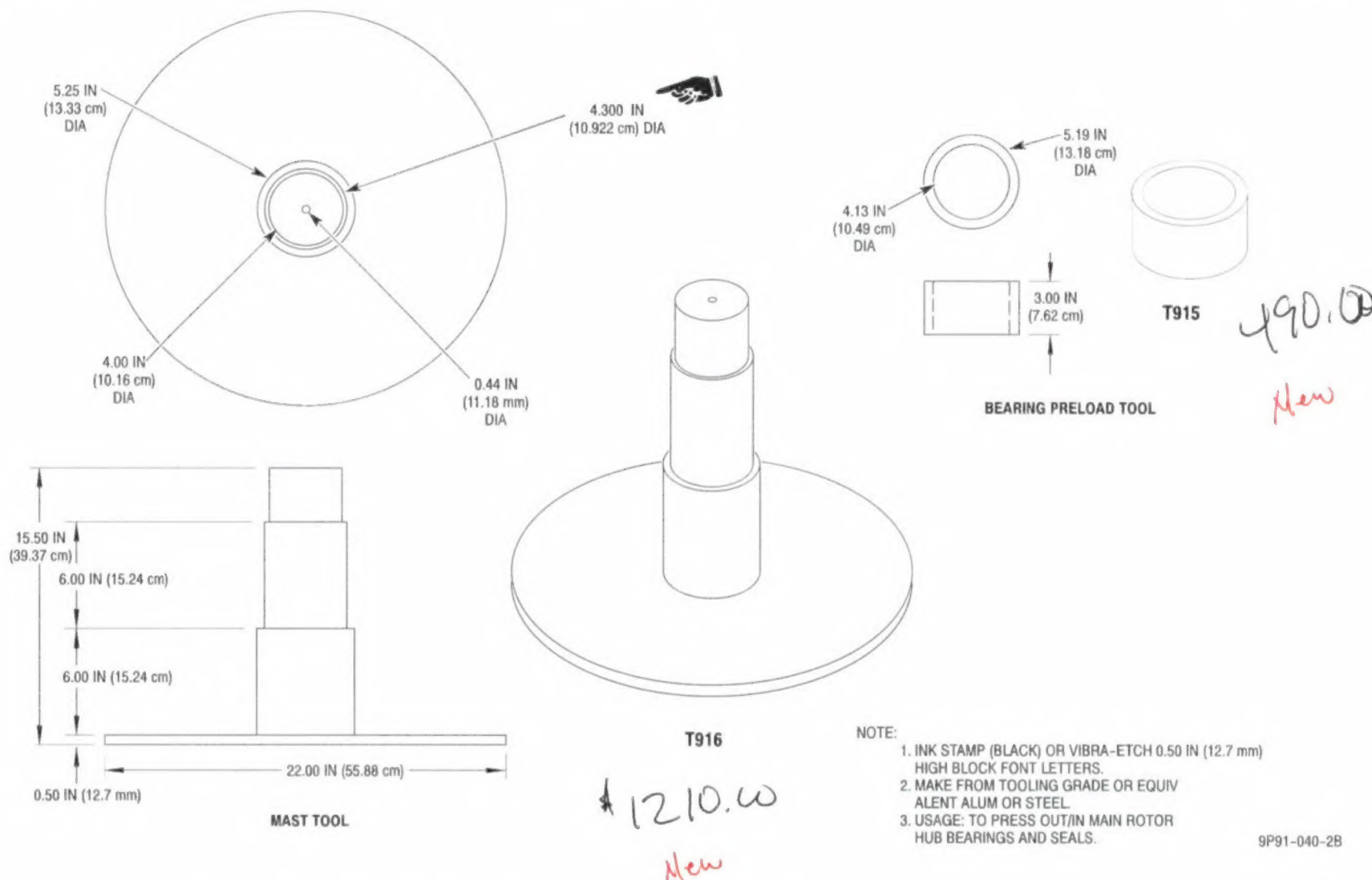
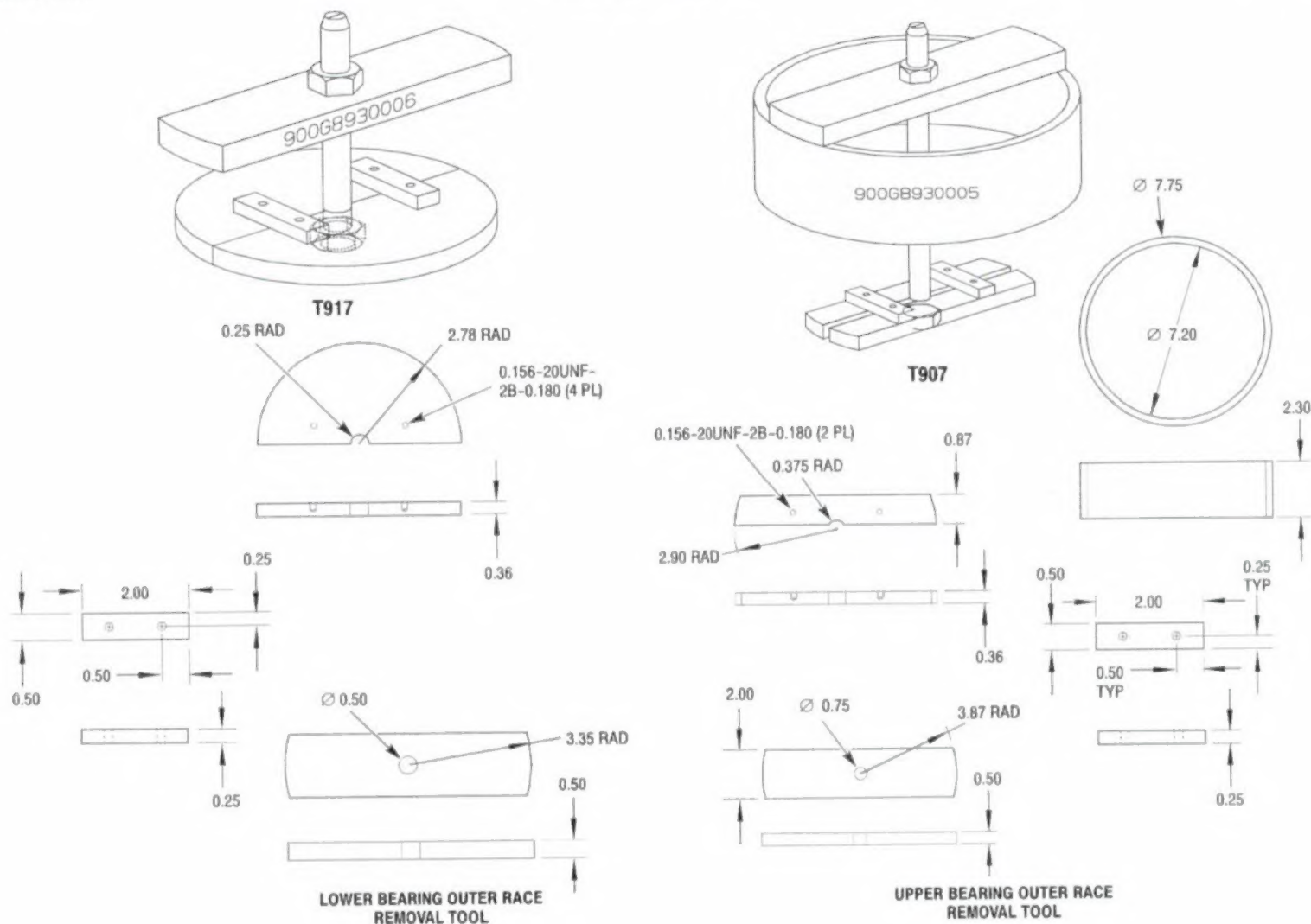


Figure 18. Main Rotor Hub Details – Removal / Installation Tools (Sheet 2 of 3)

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9P91-040-3

Figure 18. Main Rotor Hub Details – Removal / Installation Tools (Sheet 3 of 3)

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